

## SPA 760

**CATEGORY** Metal spray wires

**TYPE** Seamless fluxcored medium alloyed metal spray wire for wear resistant layers with high hardness.

**APPLICATIONS** Seamless fluxcored medium alloyed metal spray wire for wear resistant layers with high hardness to offer excellent wear resistance as for agriculture, mining, cement industry and similar applications

**PROPERTIES** Due to the high resistance to cracking and toughness, all spray metal requires no buffer layer except on materials considered critical. In this Situation Ceweld SP NiAl is recommended. Suited for wear parts subject to heavy abrasion. The interpass temperature should be maximum 250°C. The spray deposit is machinable by special carbide tools.

**CLASSIFICATION** EN ISO 14700: TFE-4

**SUITABLE FOR** Cones, presses, slides, shifts, pumps, sleeves, axes etc...

**APPROVALS** CE approved

**WELDING POSITIONS:**



**SPRAY METAL ANALYSIS %**

C	Mn	Si	Cr	Mo
0.50	1.50	0.60	6.00	0.90

**MECHANICAL PROPERTIES**

Heat Treatment	Bonding strength ASTM C633	Rm (N/mm <sup>2</sup> )	A5 (%)	Impact Energy (J) ISO-V			Hardness HRC
				-20°C	-40°C	-60°C	
as sprayed							30-58

**SPRAY PARAMETERS / PACKING**

D (mm)	Welding Parameters		Packing	
	Voltage (V)	Current (A)	spool type	kg / spool
1.6	32	100-200	K-300	16
2.4	34	150-280	K-300	16
3.2	36	220-400	K-415	25

**REDRYING TEMPERATURE** not required